

Date: Thursday, 2/23/2006 10:21:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH PLATE
Job Number	: 25903		
Estimate Number	: 10511		
P.O. Number	: N/A	Part Number	: D2621
This Issue	: 2/23/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2621 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25474	Drawing Revision	: B
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/15/2006
Checked & Approved By	: <u>06-02-23</u>	Qty:	30
Comment	: Est: C 02.02.28 Added inspection level 8 and level 5	Um:	Each
	SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 1.9688 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch:

M18019 18 M1740032 pc 50

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 4.000" x 2.130"

J.F. 06/02/25 50

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio and Dwg D2621

2- Deburr

Identify as D2621

J.F. 06/02/25 50

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/02/25 50

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06.02.25 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 06-02-28

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0 06-02-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 06-02-28

50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5753

9.0 06/2/28 50

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

9.0 06/03/01

Job Completion



9.0 06-03-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

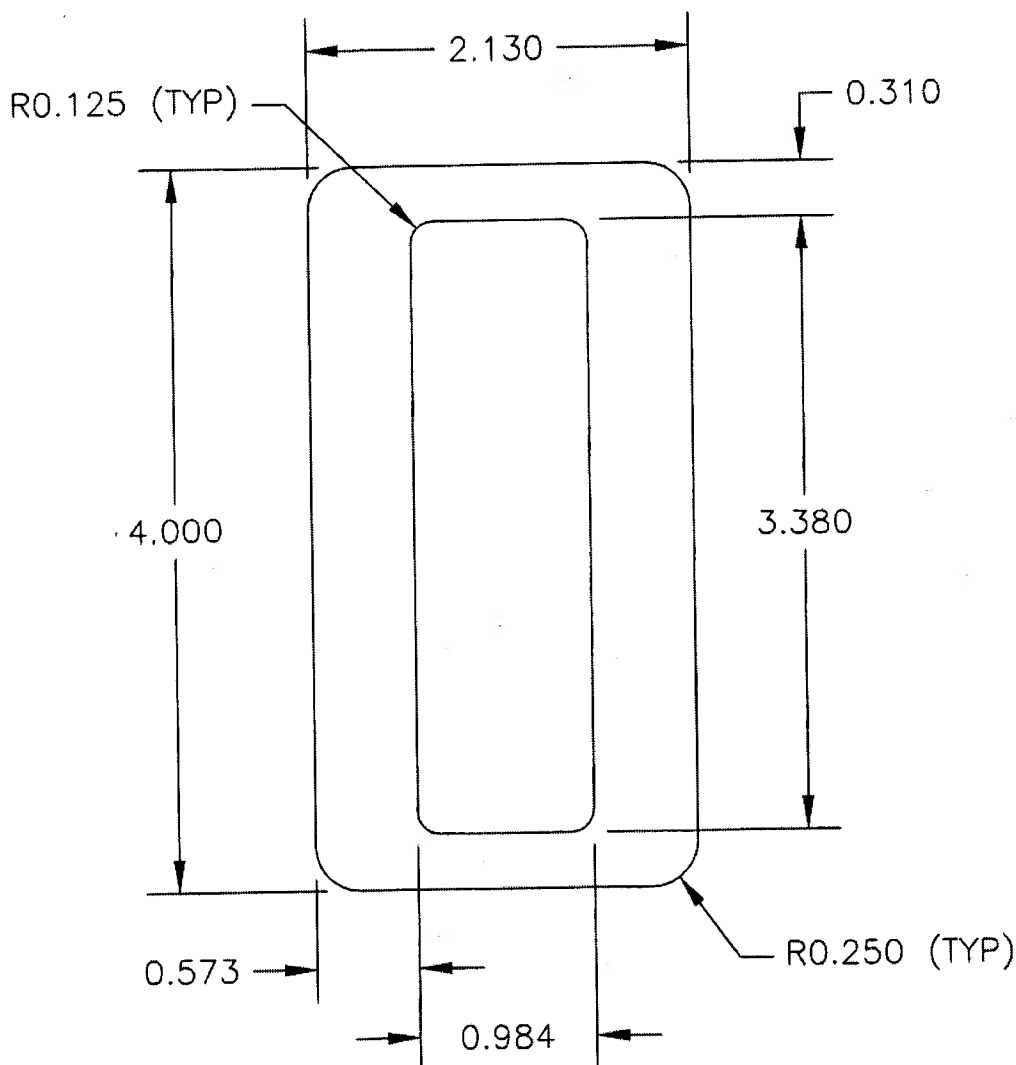
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK

FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25903

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